

Date: Friday, 01/08/2008 10:43:14 AM  
User: Julie Lecocq

## Process Sheet

Bush

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40906

Part Number: D3303043

Job Number:



Seq. #: Machine Or Operation:

Description :

16 MS20470AD4-4 Rivet

*M107823*

*SAD 08/08/08*

*(X)*

5.0 MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 96.0000 Each(s)

Nutplate

Pick:

Qty Part Number  
4 MS21075L3

Description  
Nut Plate

Batch

*M108757*

*SAD 08/08/08*

*(8)*

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



*(PTD)*

Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Assemble as per Dwg D3303
- 2- Identify as D3303-043

*08/08/08* *SAD 08/08/08*

*(8)*

7.0 QC5

INSPECT WORK TO CURRENT STEP



*S 08/08/08 X8*

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



*(X)*

*M106442*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*\*MASK THREADS PRIOR TO PAINT\*\*\*\*

START TIME:

*8:15*

OVEN TEMPERATURE:

*320°F*

FINISH TIME:

*8:45*

*m-1 08/08/12*

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(X)*

Comment: INSPECT POWDER COAT

*08-08-12*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 188*

*18 08/08/12 X6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-043 PAR #: N/A Fault Category: Prod/func ADs met/deg NCR: Yes No DQA: 10 Date: 08/08/12  
 QA: N/C Closed: 10 Date: 08/08/12

NCR: <u>40906</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/8/11</u>	<u>60</u>	During inspection 3 assembly were found with 1 rivet installed incorrectly in each. R.C. Human error. moved During Routing.	<u>107327</u>	Drill out incorrect rivets and replace MS20470AD4-4 <u>B</u>	<u>SAY</u> <u>08/08/11</u>	<u>S</u> <u>8/8/11</u>	<u>107327</u>	<u>107327</u>

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:43:14 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40906

Part Number: D3303043

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(S)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/08/12

Job Completion



12/08/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

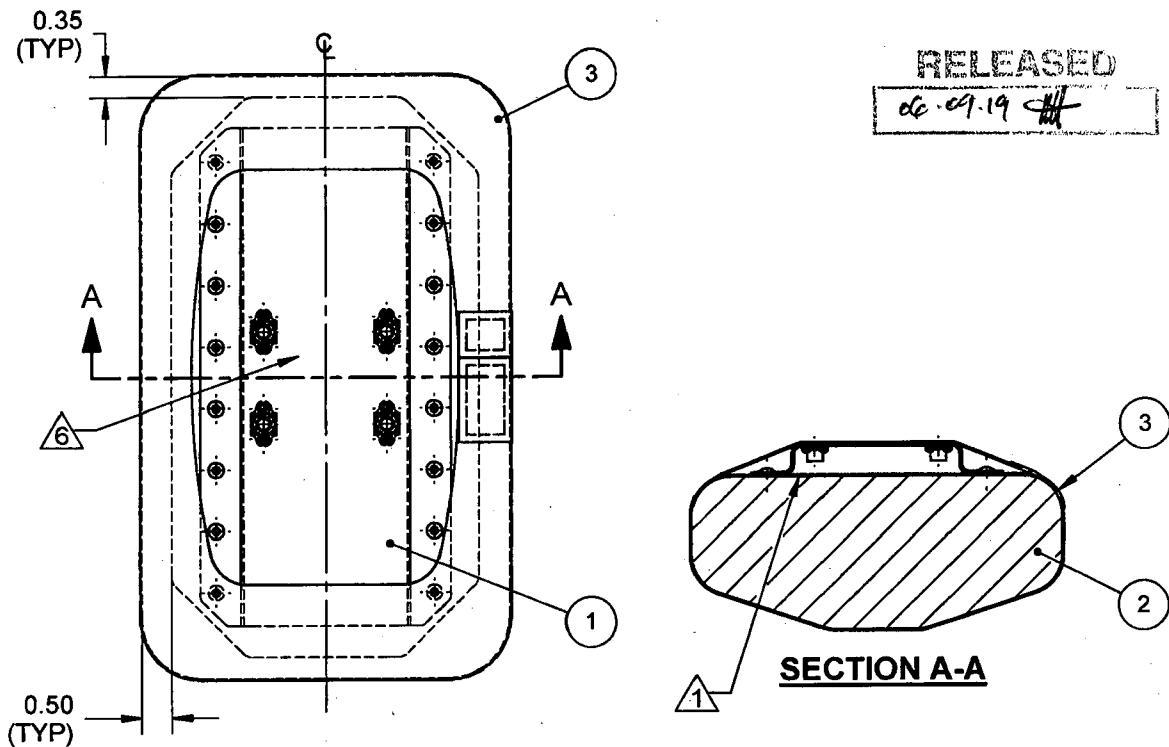
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>RF</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
REV B	DATE 06.08.17	DESCRIPTION UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



### D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

#### NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT NO. 100000  
ELIGIBILITY SEE PDA04-11"

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WITHOUT NOTICE

WORK ORDER

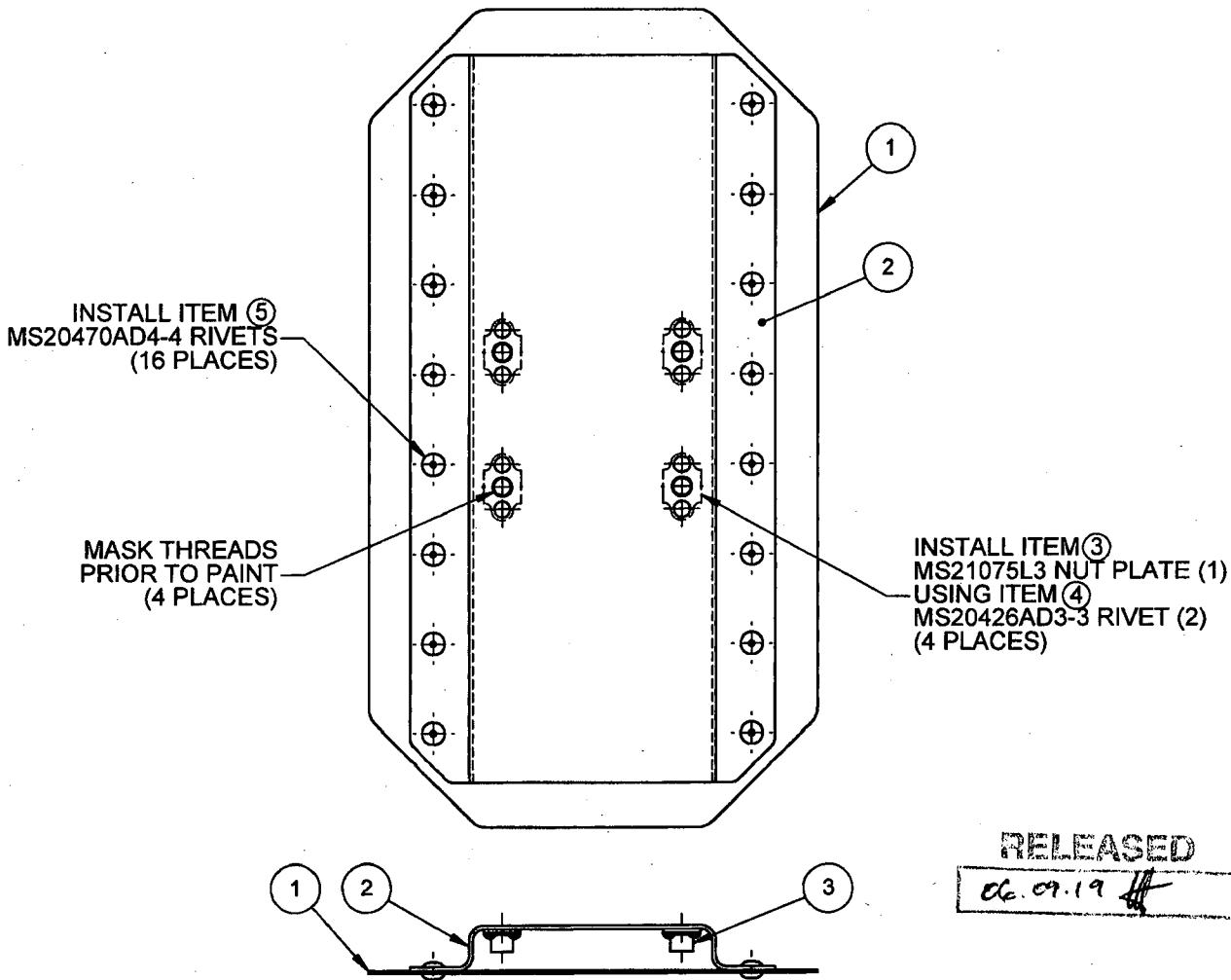
NO. 100000

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**DART**

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CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 2 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>	SCALE 1:2	



### D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

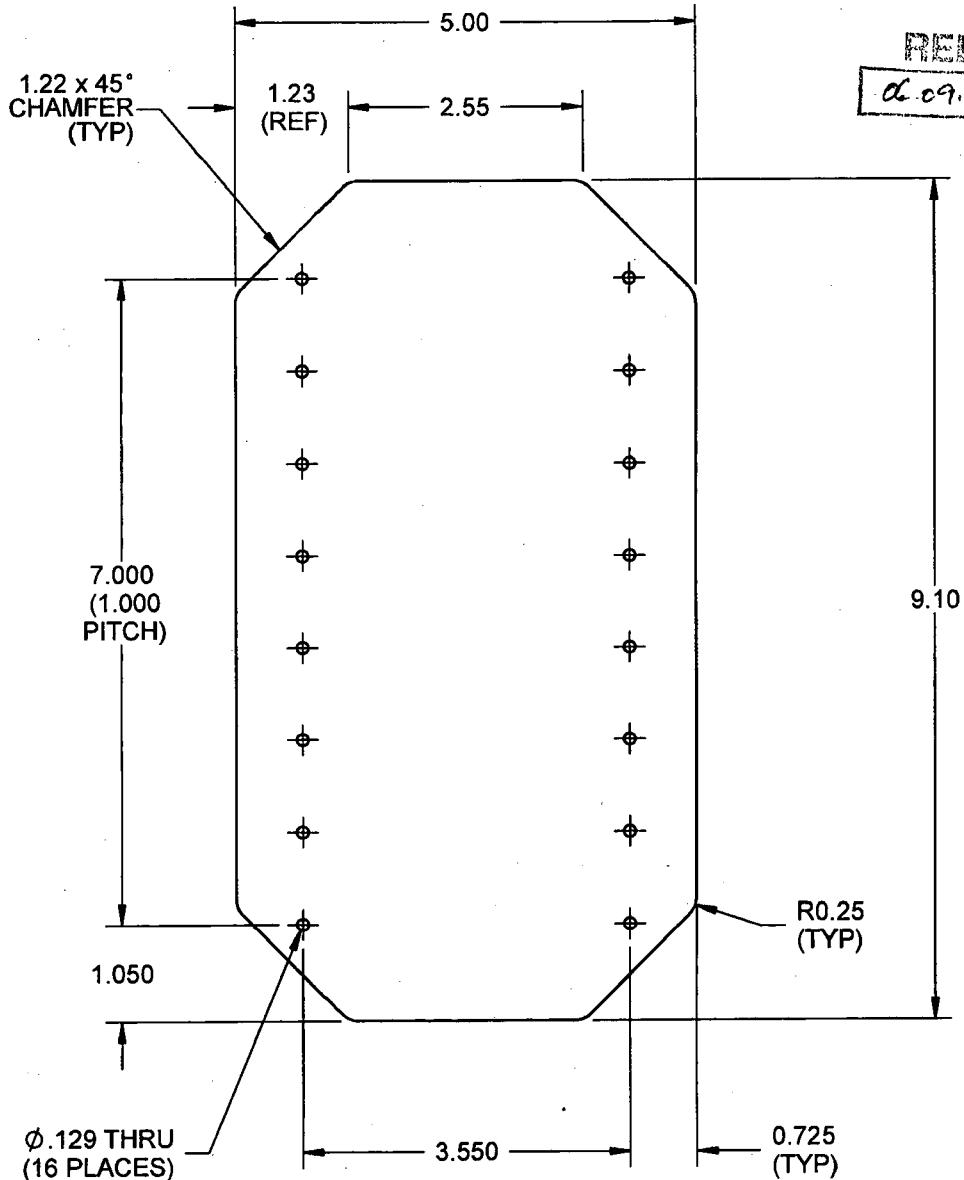
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CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 3 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>	SCALE <b>1:2</b>	

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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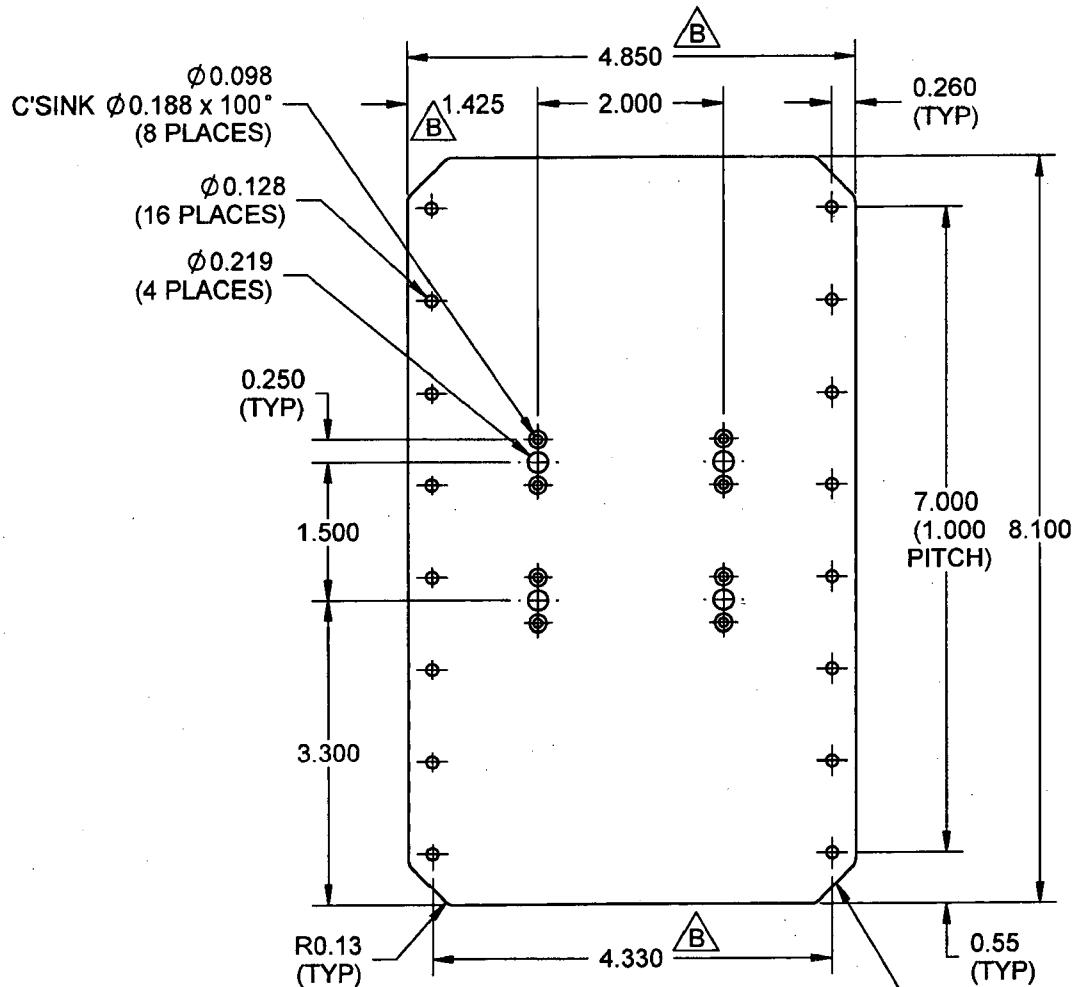
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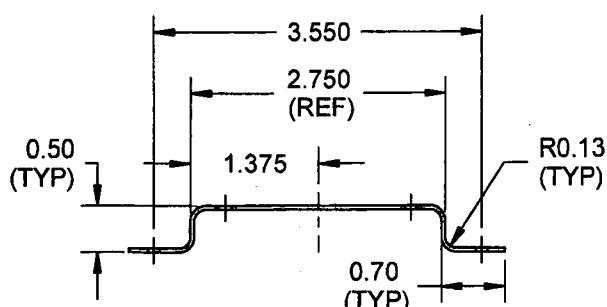
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CHECKED <i>PH</i>	APPROVED <i>AS</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 4 OF 4
DATE 06.08.17	TITLE <b>HEAD REST</b>	SCALE 1:2	

**△ B D3303-3F BRACKET FLAT PATTERN**

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WORK ORDER  
NO. 40900

**D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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